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Wednesday, 21/11/2007 3:18:26 PM Date User: Linda Lacelle **Process Sheet** : HELI-ACCESS STEP LH (FOLDING) : CU-DAR001 Dart Helicopters Services Customer **Drawing Name** Job Number : 35956 **Estimate Number** : D412630033 Part Number P.O. Number S.O. No. : NA : IIN D412-630 **Drawing Number** This Issue : N/A Project Number Prsht Rev. Туре : LARGE FAB ASSY Drawing Revision First Issue Material **Previous Run** : 23/11/2007 Qty: **Due Date** Written By Checked & Approved By Comment : Est. Rev:A New Issue 06-11-08 JLM EC verified by:DD ecn 1019, added d2807-041 est rev B **Additional Product** Job Number: Seq. #: Description: Machine Or Operation: DOCUMENT CONTROL 1.0 DC Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG003 2.0 D2012107 Clevis Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Clevis Pick: Description Batch Qty Part Number 33785 Clevis 1 D2012-107 3.0 D2803041 Bracket Assembly Comment: Qty.: Total: 1.0000 Each(s) 1.0000 Each(s)/Unit

Bracket Assembly

Pick:

Qty Part Number 1 D2803-041

Description

Bracket Assembly LH

4.0 D2804041 **Bracket Assembly**



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Pick:

Qtv Part Number D2804-041

Description Bracket Assembly LH Batch /529401

W/O:		WORK ORDER CHAN	GES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	۱:	_ Date: _	
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		Description of NC		Corrective Action Section B	Varification	A					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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Date: Wednesday, 21/11/2007 3:18:26 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Part Number: D412630033 Job Number: 35956 Job Number: Seq. #: Description: Machine Or Operation: 5.0 D2807041 GAS SPRING ASSEMBLY Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Support Prop Batch: 133596 Washer 6.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Washer Pick: Part Number Description 2 Washer D2813 STEP ASSEMBLY, 7.0 D3562041 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description D3562-041 Step Weldment LH D33951 Bushing Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Bushing Pick: Qty Part Number Description D3395-1 Bushing 9.0 AN3C21A BOLT 2.0000 Each(s)/Unit Total: Comment: Qty.: 2.0000 Each(s) **BOLT** Pick: Description Batch Qty Part Number W10118 Bolt AN3C21A

W/O:		WORK ORDER C	HANGES	···			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	}	Verification	Annroval	Ammental				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
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Date: Wednesday, 21/11/2007 3:18:26 PM User: Linda Lacelle **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630033 Job Number: 35956 Job Number: Description: Seq. #: **Machine Or Operation:** Bolt 10.0 AN8C16 2.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Bolt Pick: M162736 Part Number Description AN8C16 Bolt AN310C8 11.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Nut Pick: Batch 1728 Qty Part Number Description 2 AN310C8 12.0 MS24665302 Comment: Qty.: 2.0000 Each(s) 2.0000 Each(s)/Unit Total: Cotter Pin Pick: Description Batch Qty Part Number 116941 MS24665-302 Cotter Pin (or AN380C3-4) Washer NAS1515H3 13.0 6.0000 Each(s)/Unit Total: 6.0000 Each(s) Comment: Qty.: Washer Pick: Qty Part Number Description NAS1515H3 Washer WASHER NAS1515H5L 14.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) WASHER Pick: Qty Part Number Description NAS1515H5L Washer

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DATE	STEP	PR	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cat	tegory:	NC	R: Yes	No DQ	A:	Date:	
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descri	Section B ption	Sign & Date	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 21/11/2007 3:18:26 PM User: Linda Lacelle **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 35956 Part Number: D412630033 Job Number: Seq. #: **Machine Or Operation:** Description: 15.0 NAS1515H8 Washer Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Washer Pick: Qty Part Number Description 104811 Washer NAS1515H8 MS210433 16.0 Nut Comment: Qty.: 4.0000 Each(s) 4.0000 Each(s)/Unit Total: Nut Pick: M(03192, Qty Part Number Description MS21043-3 Nut 17.0 MS24693C280 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Screw Pick: Description Qty Part Number Screw (or MS24694-C565) MS24693-C280 18.0 SMALL FAB 1 ملاعد Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: MICH929 COAT exposed HARDWARE WITH LPS PROCYON. 19.0 QC5 Comment: INSPECT WORK TO CURRENT STEP

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		Description of NC		Corrective Action Section B		Verific	cation	Approval	Approval
DATE	STÉP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Sect.	ion C	Chief Eng	QC Inspector
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Date: Wednesday, 21/11/2007 3:18:26 PM User: Linda Lacelle **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630033 Job Number: 35956 Job Number: Seq. #: Description: Machine Or Operation: 20.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Pick Packing Kit 21.0 D28061 Bushing Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Bushing Pick: Packing Kit Part Number Description 2 D2806-1 Bushing 22.0 D28063 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Bushing 50/ Pick: Packing Kit Part Number Description D2806-3 Bushing 23.0 D28105 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Strut Pick: Packing Kit Qty Part Number Description 1 D2810-5 Strut 24.0 D33961 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Spacer Pick: Packing Kit Qty Part Number Description 2 D3396-1 Spacer AN4C6A 25.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Bolt Pick: Packing Kit Batch Qty Part Number Description Page 5

Dail Ac	OSpace	-tu						
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DATE	STEP	PROCEDURE CHANGE	Ву	Da	ıte	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #: Fault Category: _	NCR: Ye	es No	DQA	:	Date:	
			QA	: N/C C	losed	:	_ Date: _	

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
·		Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 21/11/2007 3:18:26 PM User: Linda Lacelle **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 35956 Part Number: D412630033 Job Number: Seq. #: Description: **Machine Or Operation:** AN4C6A Bolt 26.0 AN4C10A Bolt Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description AN4C10A Bolt 27.0 AN4C15A Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 2 AN4C15A Bolt AN44C7A 28.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Eyebolt Pick: Packing Kit Qty Part Number Description W101711 AN44-C7A Eyebolt 29.0 AN5C15A Comment: Qty.: 2.0000 Each(s) 2.0000 Each(s)/Unit Total: Bolt Pick: Packing Kit Qty Part Number Description AN5C15A Bolt 30.0 NAS1515H4 Washer Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description NAS1515H4 Washer 7

Dart Ae	rospace L	_td							
W/O:			WORK ORDE	R CHANGES	S				
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Part No	:	PAR #:	Fault Category:		NCR: Yes	No DQ	4: 1	⊇ Date:ੴ	11/23
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DATE	STEP	Description of NC	Corrective Ad			Verific	ation	Approval	Approval
	J. L.	Section A	Initial Action [Description	Sign 8	Section	nn C	Chief Eng	OC Inspector

		WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
	Description of NC		Corrective Action Section B			Annroval	A =======
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto
				*			
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Initial Chief Eng Chief	STEP Section A Initial Chief Eng Chief Eng Sign & Date Verification Section C Section C	STEP Description of NC Section A Corrective Action Section B Verification Section C Chief Eng Ch

Date: Wednesday, 21/11/2007 3:18:26 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP LH (FOLDING) Job Number: 35956 Part Number: D412630033 Job Number: Seq. #: Description: **Machine Or Operation:** NAS1515H5 31.0 Washer Comment: Qty.: Total: 7.0000 Each(s) 7.0000 Each(s)/Unit Washer Pick: Packing Kit Qty Part Number Description 7 NAS1515H5 Washer MS210434 32.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description MS21043-4 MS210435 33.0 Comment: Qty.: 3.0000 Each(s) 3.0000 Each(s)/Unit Total: Nut Pick: Packing Kit Description Qty Part Number 3 MS21043-5 Nut 34.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING PACKAGING RESOURCE #1 35.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-033 Location: PPP Rev: 36.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion In Stiller3

Form: rprocess

Page 7

W/O:				WORK O	RDER C	CHANG	ES				
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Part No			PAR #: F	ault Category:	,		NCR: Yes	No DO	Δ.	Date:	

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Corrective Action Section B			Ammanal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
												
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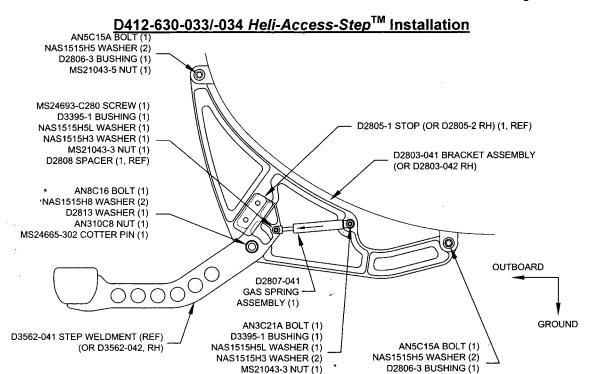


FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step[™] Installation (View rotated 90° CW)

D2809 SPACER (1; REF)

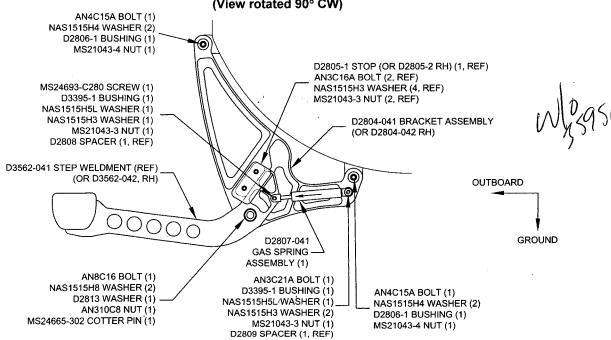


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step[™] Installation (View rotated 90° CW)

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Revision:

MS21043-5 NUT (1)

Date:

07.09.30

: HELI-ACCESS STEP LH (FOLDING)

Date:

Wednesday, 11/21/2007 3:18:02 PM

User

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Type

Job Number 🦘 😼 : 35956

Estimate Number P.O. Number

: 11/21/2007 This Issue

: NC

: 12567

Prsht Rev.

: // First Issue Previous Run

: 35797

Written By Checked & Approved By

Comment

: Est. Rev:A

est rev B

New Issue 06-11-08 JLM

ecn 1019, added d2807-041

: LARGE FAB ASSY

EC verified by:DD

Drawing Name

Part Number

: D412630033 · IIN D412-630

Drawing Number Project Number

: N/A

: L **Drawing Revision**

Material

Due Date

: 11/23/2007

Qty:

1 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 DC



DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

07.11.21

2.0

D2012107



Total: 1.0000 Each(s)/Unit

1.0000 Each(s)

REFERENCE ONLY

Clevis

Clevis

Comment: Qty.:

Pick:

Qty Part Number Description

Clevis

Batch

3.0

1 D2803041

Bracket Assembly



D2012-107

Total: 1.0000 Each(s)/Unit

1.0000 Each(s)

Comment: Qty.: **Bracket Assembly**

Pick:

Qty

Part Number

Description

Batch

D2803-041

Bracket Assembly LH

4.0

D2804041

Bracket Assembly

Comment: Qty.:

1.0000 Each(s)/Unit

Total:

Bracket Assembly

1.0000 Each(s)

Pick: Qty

Part Number

Description

Batch

D2804-041 1

Bracket Assembly LH

Job Completion

